We claim:

1. A method of making a multi-color textile substrate using a single dye formula comprising the steps of:

providing a substrate containing synthetic fibers, wherein said substrate has base regions where the synthetic fibers have a first fiber orientation and patterned regions where the synthetic fibers are less oriented than the fibers in the base regions,

dyeing said substrate with a single dye formula containing at least one dye from at least two of the categories of a) high contrast dyes, b) medium contrast dyes and c) low contrast dyes, to thereby produce a multi-colored fabric.

2. The method according to Claim 1, wherein said step of dyeing the substrate comprises exposing substantially the entire substrate to a single dye formula.

3. The method according to Claim 1, wherein said substrate is in the form of a yarn or fabric.

4. The method according to Claim 1, wherein said patterned regions that are less oriented are produced by thermally modifying those regions.

5. The method according to Claim 1, wherein said substrate is a yarn, and said patterned regions are formed by varying the draw ratio when the yarn is processed.

6. The method according to Claim 1, wherein the synthetic fiber is polyester and wherein high contrast dyes have a DL* value greater than 4.4, medium contrast dyes have a DL* value of greater than 2.0 to 4.4, and low contrast dyes have a DL* value of up to 2.0.

7. A fabric produced according to the method of Claim 1.

8. A multi-colored substrate comprising:

a substrate containing synthetic fibers, wherein said substrate comprises base regions where the synthetic fibers have a first fiber orientation and patterned regions where the synthetic fibers are less oriented than the fibers in the base regions, wherein the patterned regions are of a different color from said base regions, wherein the color in the base regions contains the same dyes as the color in the patterned regions, and wherein the patterned regions contain a greater concentration of at least one dye than the base regions and substantially the same concentration of at least one dye as the base regions.

9. A substrate according to Claim 8, wherein said substrate is a fabric.

10. A substrate according to Claim 9, wherein said fabric is selected from the group consisting of woven fabrics, knit fabrics, and nonwoven fabrics.

11. A substrate according to Claim 8, wherein said substrate is yarn.

12. A fabric according to Claim 8, wherein said synthetic fibers are selected from the group consisting of polyester, nylon and aramid fibers.

13. A fabric according to Claim 8, wherein the Delta E^*_{ab} between said base regions and patterned regions is at least about 3.0 and the DH* between said base regions and patterned regions is at least about 1.5.

14. A method of making a multi-color textile substrate using a single dye formula comprising the steps of:

providing a substrate containing synthetic fibers, wherein the substrate has base regions where the synthetic fibers have a first fiber orientation and patterned regions where the synthetic fibers are less oriented than the fibers in the base regions,

performing a number of individual dyeings using individual dyes on said fabrics to produce a plurality of dyed fabrics;

categorizing said dyed fabrics according to whether the base regions and patterned regions exhibit high contrast, medium contrast, or low contrast; then

dyeing the substrate with a single dye formula containing at least one dye from at least two of the categories of a)high contrast dyes, b) medium contrast dyes, and c) low contrast dyes, to thereby produce a multi-colored fabric.

15. The method according to Claim 14, wherein said synthetic fibers are polyester, and wherein high contrast dyes have a DL* value greater than 4.4, medium contrast dyes have a DL* value of greater than 2.0 to 4.4, and low contrast dyes have a DL* value of up to 2.0.